

# Work Order ID 81865

March-20-12 9:50:34 AM

**\*81865\***

Page 1

Item ID: D4436-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Bracket Assembly  
 Start Date: 3/20/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 3/20/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4436	A

100 0.00  
**\*100\***  
 Small Fab Memo 0.00  
 Small Fab Assemble as per dwg and intall grommet

*SB 12/03/20*

110 QC5- Inspect part completeness to step on W/O 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

*JA 12/3/20*

160 Identify as per dwg & Stock Location: 441 0.00  
**\*160\***  
 Packaging Memo 0.00  
 Packaging

*12/3/20 [Signature]*

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Page 2

Item ID: D4436-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Bracket Assembly  
Start Date: 3/20/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 3/20/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/20

MF  
12-03-20

# Picklist Print

March-20-12 9:50:34 AM

Page 1

Work Order ID: 81865

Parent Item: D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 3/20/12

Required Date: 3/20/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC IPP RevB 11.12.22 per PA2  
EC verified by:JLM IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4440-1		Manufactured	No			100	Each	20.0000	1	1		SB 12/03/20	
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	Location	Loc Qty	Loc Code
	prelim	2	
	74759	2	
	PREst	8	
	77917	8	
	ST139F	10	
	79372	10	

D4435-043		Manufactured	No			100	Each	33.0000	1	1		SB 12/03/20	
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	Location	Loc Qty	Loc Code
	ST	13	
	79612	3	
	80642	10	
	80644	10	
	ST139E	20	
	80643	10	

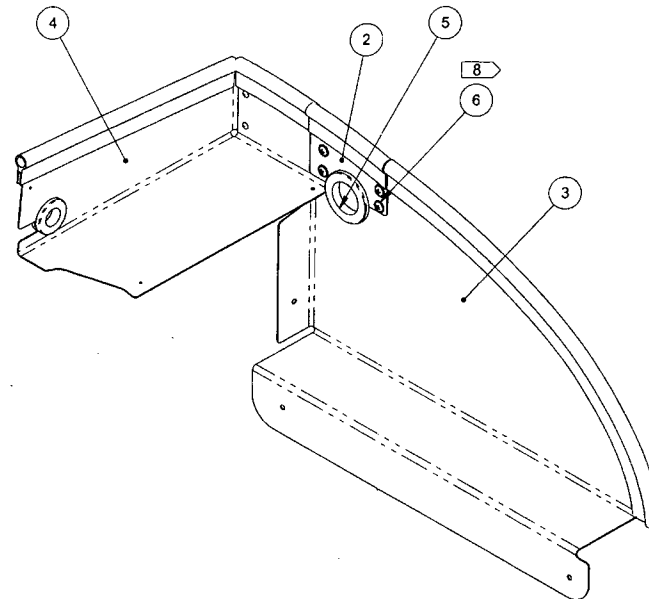
D4436-043		Manufactured	No			100	Each	0.0000	1	1		SB 12/03/20	
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D4436-045		Manufactured	No			100	Each	0.0000	1	1		SB 12/03/20	
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AN525-832R6		Purchased	No			100	Each	502.0000	4	4		SB 12/03/20	
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	Location	Loc Qty	Loc Code
	ST345	502	
	120308	2	
	120560	500	





ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



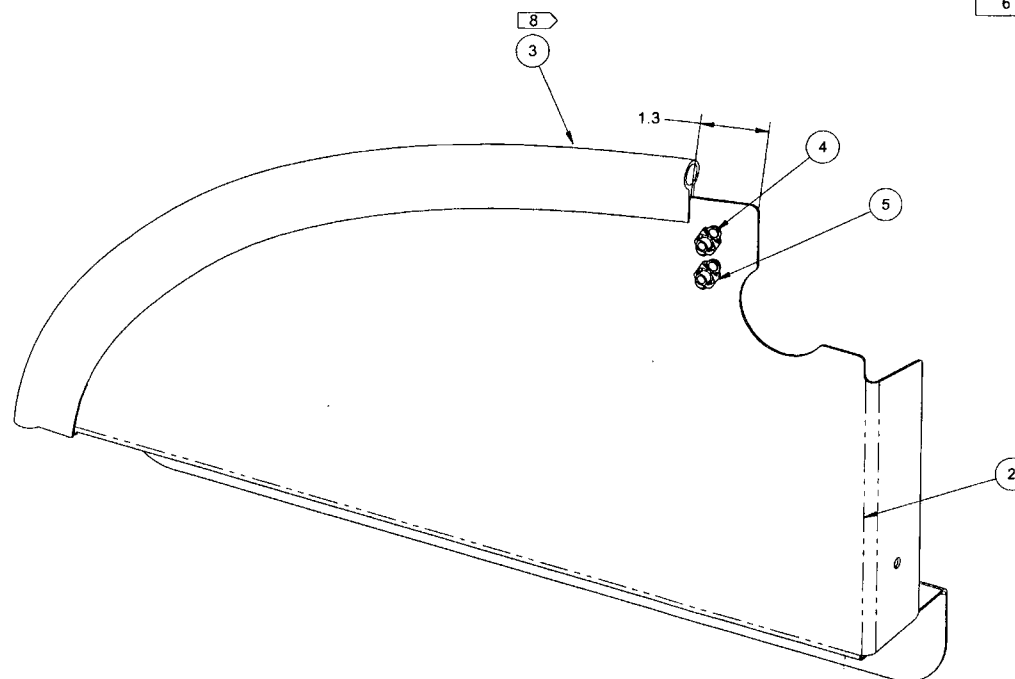
**D4436-041 AFT BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

A		NEW ISSUE		RF	12.01.17
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4436	SHEET 1 OF 7		
APPROVED		TITLE	SCALE		
DE APPR.		COVER ASSEMBLY	NTS		
DATE	12.01.17				
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



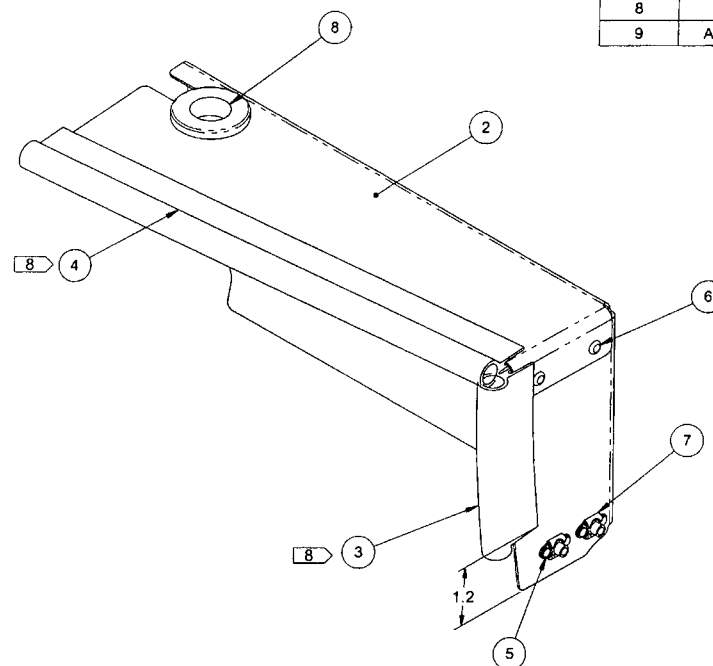
**D4436-043 AFT OUTBOARD BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 7	
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



**D4436-045 AFT INBOARD BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 3 OF 7
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2012-01-23  
MP

8 7 6 5 4 3 2 1

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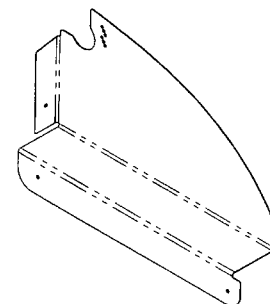
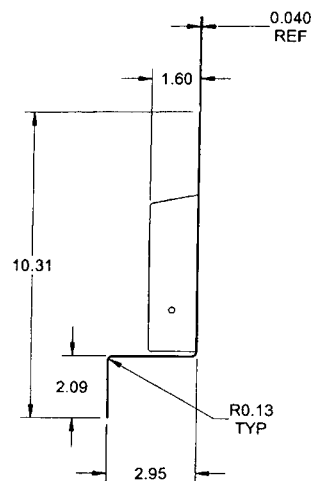
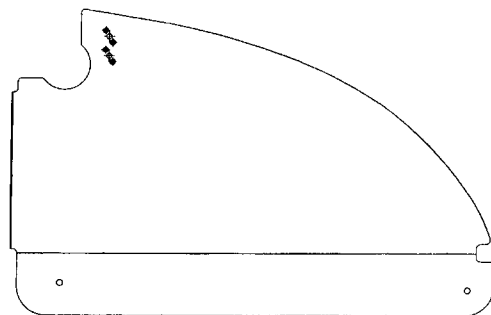
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# **D4436-1 BRACKET**

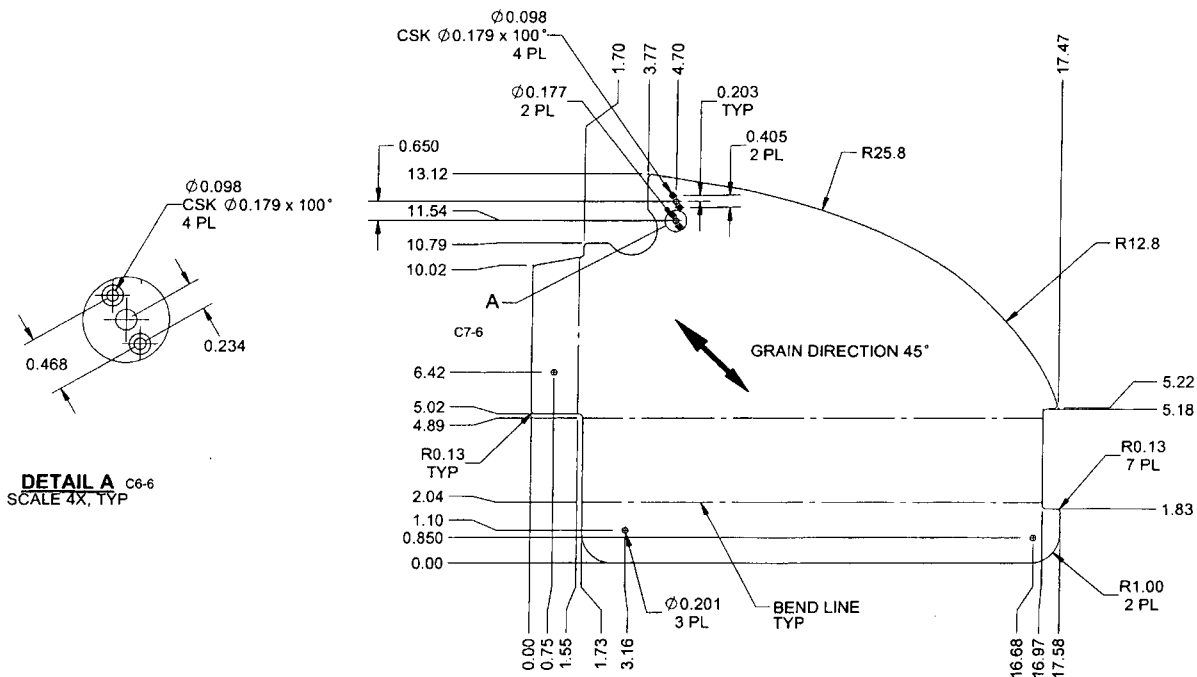
RELEASE  
2012-01-23

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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8 7 6 5 4 3 2 1



# **D4436-1F FLAT PATTERN**

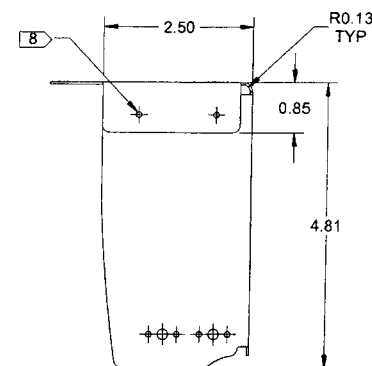
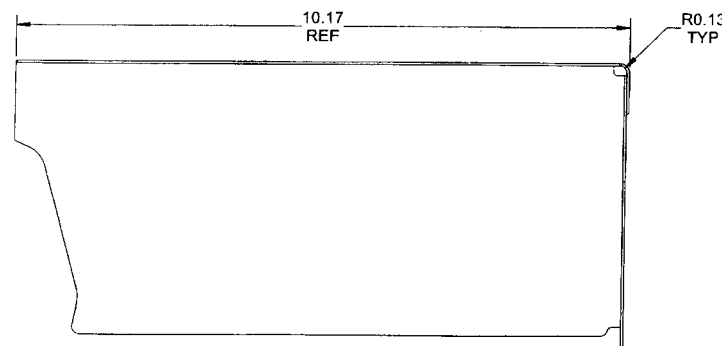
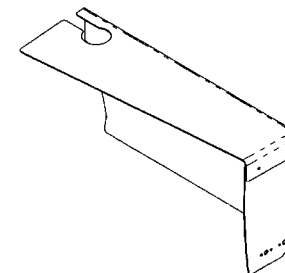
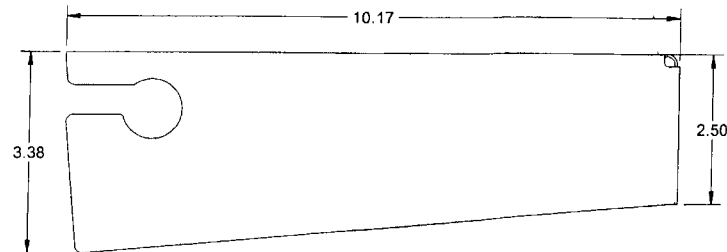
## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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2012-01-23  
*[Signature]*





# **D4436-3 BRACKET**

RELEASE  
2012-01-23  
MP

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER  $\varnothing 0.129$  HOLES THRU 2 PLACES

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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